


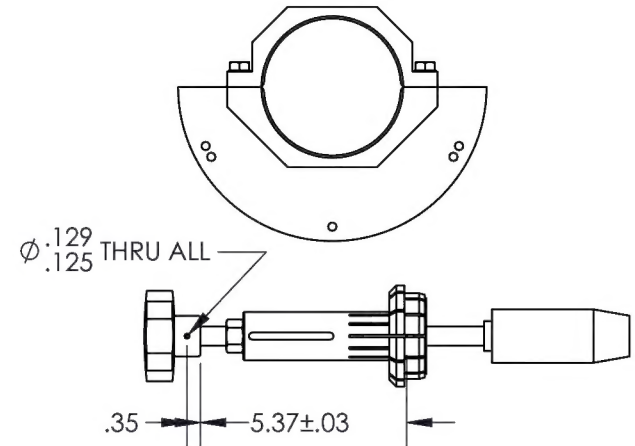
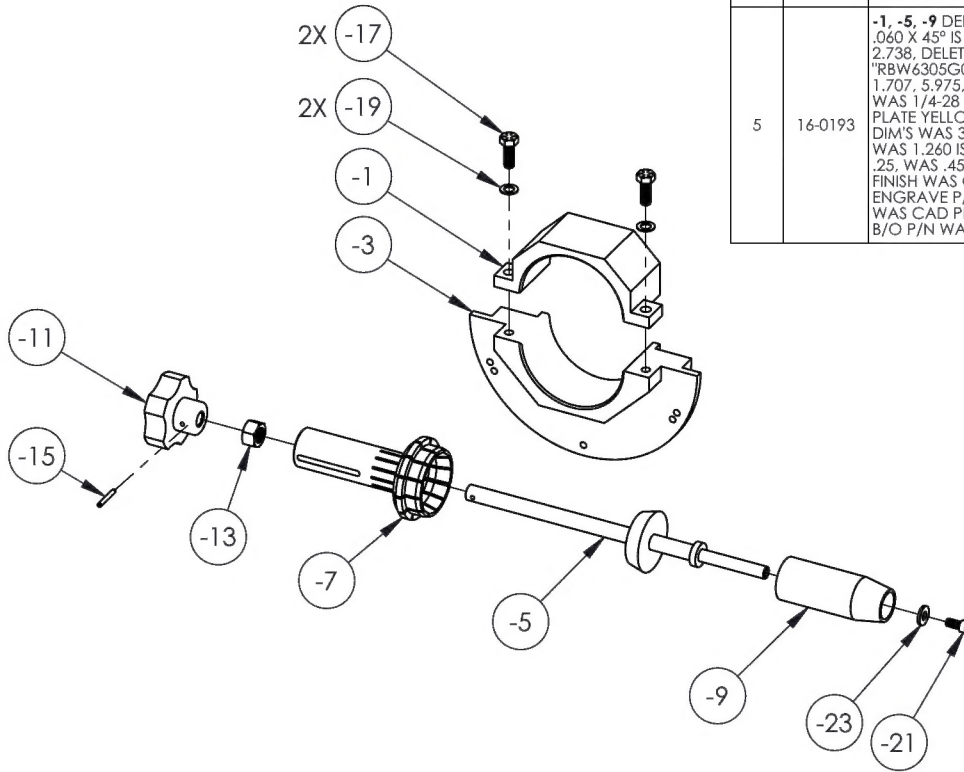


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 CH'D DIM .865 TO 1.097. ADDED MISSING DIM R.125 (2X). -3 CH'D DIM 2.405 TO 2.415. 5 HOLE BOLT CIRCLE FROM Ø.750 TO Ø.7288. 64° TO 65°. ADDED MISSING DIM R.125 (2X). -5 CH'D MATERIAL FROM 4140 TO 4140 Q&T.	1/20/2011	RJC	RW
2		-5 ADDED NOTE 2.	5/31/2011	RJC	RW
3		-1, -3, -5, -7 & -9 CH'D DIM'S TO MEET FACTORY PART.	12/14/2011	RJC	SE
4		-1 & -3 CH'D DIM'S TO MATCH PREVIOUS REV DESIGN.	1/30/2013	BIM	SE
5	16-0193	-1, -5, -9 DELETED ENGRAVE NOTE. -1 CH'D DIM'S WAS .393 IS 2X .393. WAS 2X .313 IS 2X .332. WAS .060 X 45° IS .06 X 45°. -3 CH'D DIM'S WAS .393 IS 2X .393. WAS 2X 2.090 IS 2.090. ADDED DIM 2X .513. 2.738. DELETED DIM .793. CH'D ENGRAVE NOTE WAS ENGRAVE T/N. "ASSY RBW6305G04731-3G" "RBW6305G05351-3G" S/N. "MADE IN USA" IS ENGRAVE T/N. S/N. "MADE IN USA". -5 DELETED DIM'S 1.707. 5.975. .350. Ø.125 THRU  CH'D DIM WAS 10.500 IS 10.50. WAS .500 IS 2X .50. WAS .510 IS .51. WAS 1/4-28 UNF  .625 IS 1/4-28 UNF -28  .63. ADDED HEAT TREAT RC 28-32. CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE. CH'D MAT'L WAS 4140 Q&T IS 4140/4142. DELETED NOTE 2. -7 CH'D DIM'S WAS 30° IS 11 X 30°. WAS Ø.532 IS Ø.53. WAS .030 X 45° IS .03 X 45°. WAS .150 X 15° IS .15 X 15°. WAS 1.260 IS Ø1.26. WAS .188 IS .19. WAS .150 IS .15. WAS 2.200 IS 2.20. WAS 4.728 IS 4.73. WAS .250 IS .25. WAS .450 IS .45. WAS 1.965 IS 1.97. WAS 15° IS (15°). CH'D MAT'L WAS 4140 IS 4140/4142. CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE. CH'D ENGRAVE NOTE WAS ENGRAVE T/N IS ENGRAVE P/N. -9 CH'D DIM WAS 3.580 IS 3.58. CH'D MAT'L WAS 1018 IS 1018/1020 CR. CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE. -17 CORRECTED B/O INFO WAS 1/4-28 IS 5/16-24. -23 CH'D B/O P/N WAS 91083A029 IS 98023A029.	10/27/2016	RJC	SM

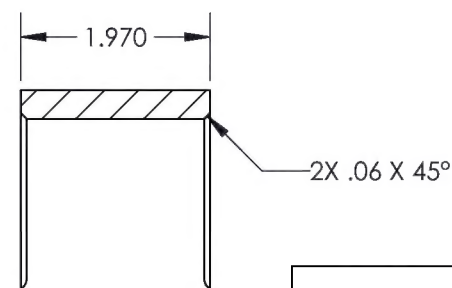
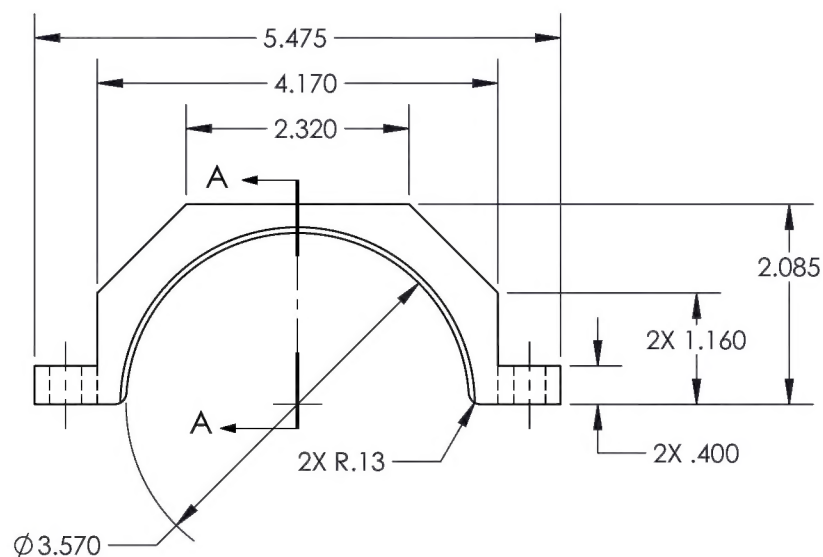
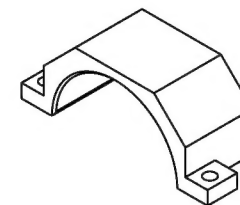
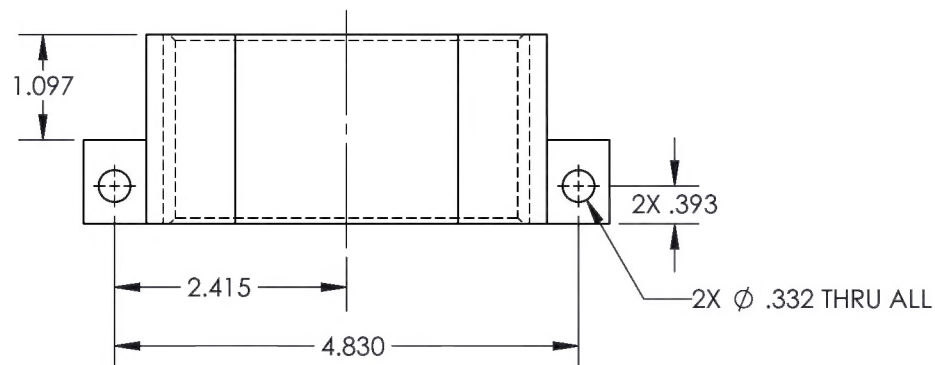


NOTE:
PART OF KIT RBW6305G01331-3G.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PUSHER RACE INSTALLER TOP	6061		2
			-3	1	PUSHER, RACE INSTALLER BOTTOM	6061		3
			-5	1	CONE	4140/4142		4
			-7	1	COLLET	4140/4142		5
			-9	1	BULLET	1018/1020 CR		6
		B/O	-11	1	KNOB	BLACK PLASTIC	Ø2.36, 1/2-13 UNC. FIVE LOBE (ESSENTA #KHY-60)	1
		B/O	-13	1	HEX NUT	STEEL, GRD 8	1/2-13 (MCMaster-CARR #94895A823)	1
		B/O	-15	1	SLOTTED SPRING PIN	STEEL	Ø1/8 X 1 (MCMaster-CARR #90692A700)	1
		B/O	-17	2	HEX HEAD CAP SCREW	STEEL	5/16-24 X 31/32 (AIRCRAFT SPRUCE #AN5-7A)	1
		B/O	-19	2	FLAT WASHER	STEEL	Ø5/16 (AIRCRAFT SPRUCE AN5-6A)	1
		B/O	-21	1	SOCKET HEAD CAP SCREW	STEEL	1/4-28 X 1/2 (MCMaster-CARR #90128A361)	1
		B/O	-23	1	FLAT WASHER	STEEL	Ø1/4 (MCMaster-CARR #98023A029)	1

DART AEROSPACE			
TITLE PUSHER, CLUTCH IN RACE INSTALLATION			
DWG NO. RBW6305G04731-3G			REV 5
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY: CLOUGH		.X ± .1 SURFACES = 125°	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: MACKOVJAK		AFTER PLATING	
SCALE 1:6		3. INTERPRET DIM AND TOL PER	
DATE 3/30/2016		ASME Y14.5M-2009	
		USED ON MODEL	
		AW139	
		SHEET 1 OF 6	

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 CH'D DIM .865 TO 1.097. ADDED MISSING DIM R.125 (2X).	1/20/2011	RJC	RW
3		-1 CH'D DIM'S TO MEET FACTORY PART.	12/14/2011	RJC	SE
4		-1 CH'D DIM'S TO MATCH PREVIOUS REV DESIGN.	1/30/2013	BIM	SE
5	16-0193	-1 CH'D DIM'S WAS .393 IS 2X .393, WAS 2X .313 IS 2X .332, WAS .060 X 45° IS .06 X 45°. DELETED ENGRAVE NOTE.	10/27/2016	RJC	SM



SECTION A-A



DWG NO.	RBW6305G04731-3G-1	REV 5
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MAT'L 6061	UNLESS OTHERWISE SPECIFIED	
HEAT TREAT	DIMENSIONS ARE IN INCHES	
FINISH CLEAR ANODIZE	.XXX ± .005	FRACTIONS ± 1/8
SPEC MIL-A-8625F, TYPE II, CLASS I	.XX ± .01	ANGLES ± .5°
	.X ± .1	SURFACES = 125 ✓
	1 BREAK ALL SHARP EDGES ✓	

DRAWN BY:	CLOUGH	1. TOLERANCES UNLESS OTHERWISE SPECIFIED
CHECKED:	DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

QA APPR:	LINDSAY	USED ON MODEL
APPROVED:	MACKOVJAK	AW139

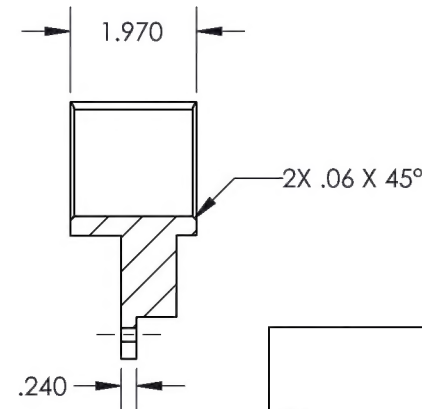
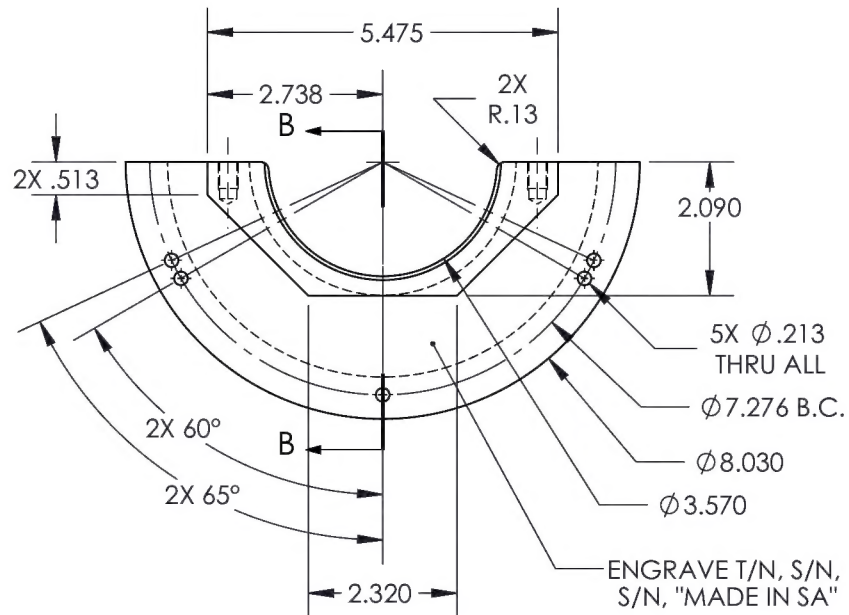
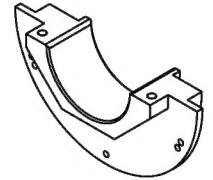
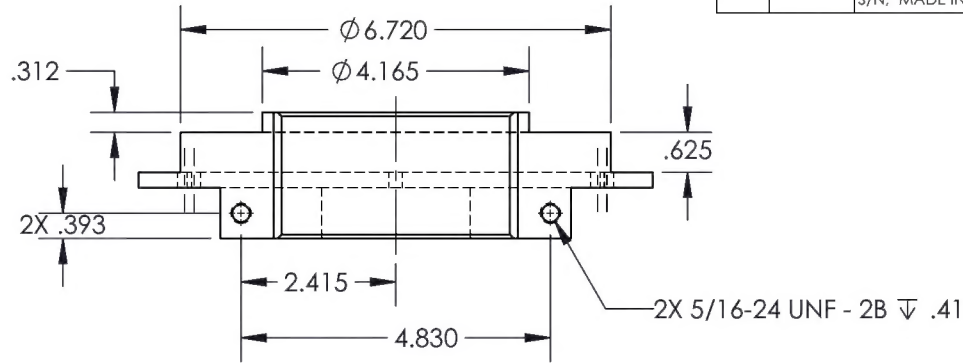
SCALE	1:2	DATE	3/30/2010	SHEET 2 OF 6
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-1

PUSHER RACE INSTALLER TOP

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-3 CH'D DIM 2.405 TO 2.415, 5 HOLE BOLT CIRCLE FROM Ø7.750 TO Ø7.288, 64° TO 65°, ADDED MISSING DIM R.125 (2X).	1/20/2011	RJC	RW
3		-3 CH'D DIM'S TO MEET FACTORY PART.	12/14/2011	RJC	SE
4		-3 CH'D DIM'S TO MATCH PREVIOUS REV DESIGN.	1/30/2013	BIM	SE
5	16-0193	-3 CH'D DIM'S WAS .393 IS 2X .393, WAS 2X 2.090 IS 2.090, ADDED DIM 2X .513, 2.738, DELETED DIM .793. CH'D ENGRAVE NOTE WAS ENGRAVE T/N, "ASSY RBW6305G04731-3G" S/N, "MADE IN USA" IS ENGRAVE T/N, S/N, "MADE IN USA".	10/27/2016	RJC	SM



SECTION B-B

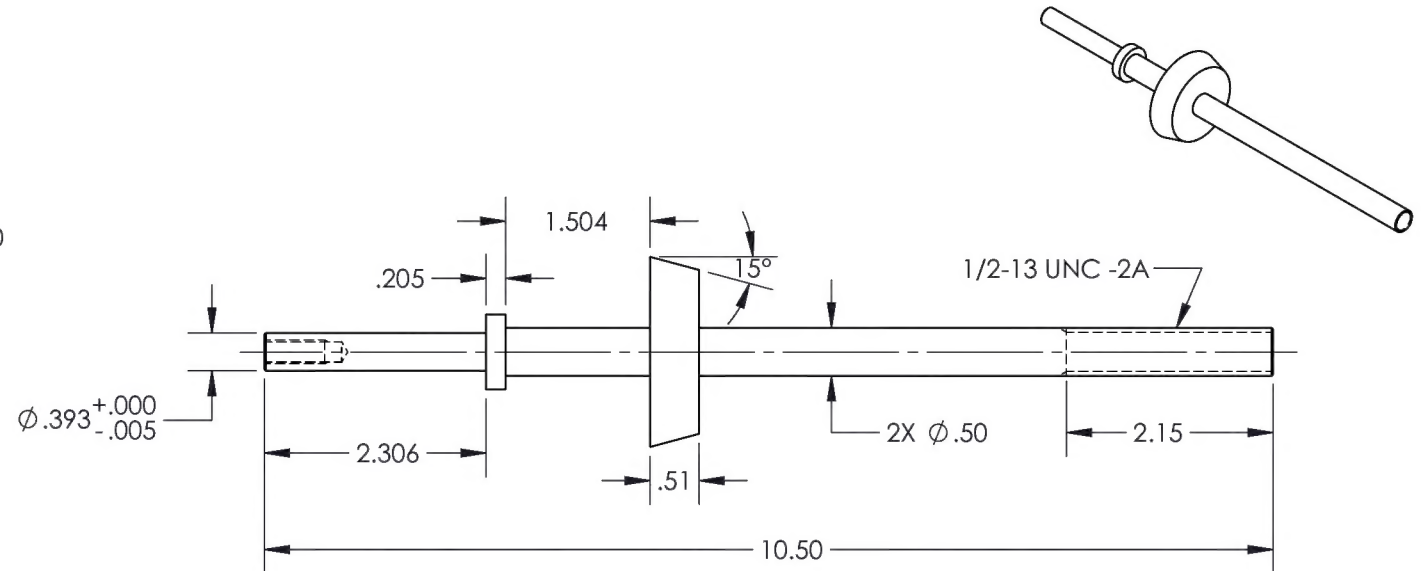
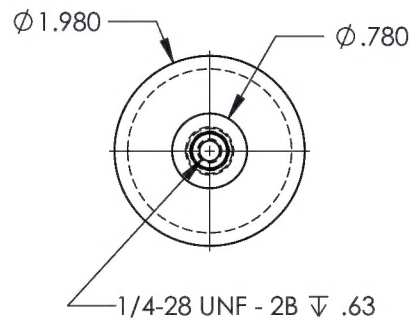
(-3)

PUSHER, RACE INSTALLER BOTTOM

DART AEROSPACE	
TITLE PUSHER, CLUTCH IN RACE INSTALLATION	
DWG NO. RBW6305G04731-3G-3	REV 5
MAT'L 6061 HEAT TREAT FINISH CLEAR ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS I	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: MACKOVJAK	
USED ON MODEL AW139	
SCALE 1:3	DATE 3/30/2010
SHEET 3 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-5 CH'D MATERIAL FROM 4140 TO 4140 Q&T.	1/20/2011	RJC	RW
2		-5 ADDED NOTE 2.	5/31/2011	RJC	RW
3		-5 CH'D DIM'S TO MEET FACTORY PART.	12/14/2011	RJC	SE
5	16-0193	-5 DELETED DIM'S 1.707, 5.975, .350, Ø.125 THRU Δ . CH'D DIM WAS 10.500 IS 10.50, WAS .500 IS 2X .50, WAS .510 IS .51, WAS 1/4-28 UNF -2B ∇ .63, ADDED HEAT TREAT RC 28-32, CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE, CH'D MAT'L WAS 4140 Q&T IS 4140/4142, DELETED NOTE 2. DELETED ENGRAVE NOTE.	10/27/2016	RJC	SM



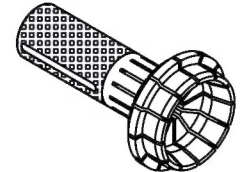
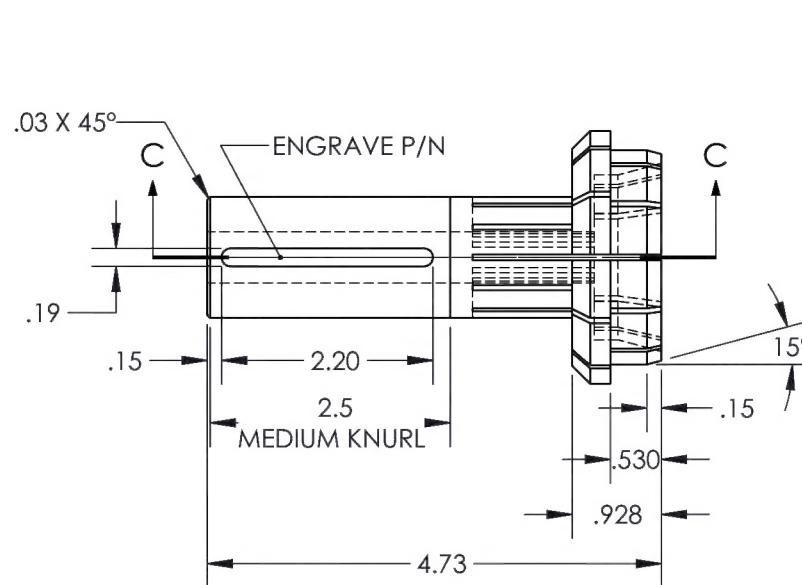
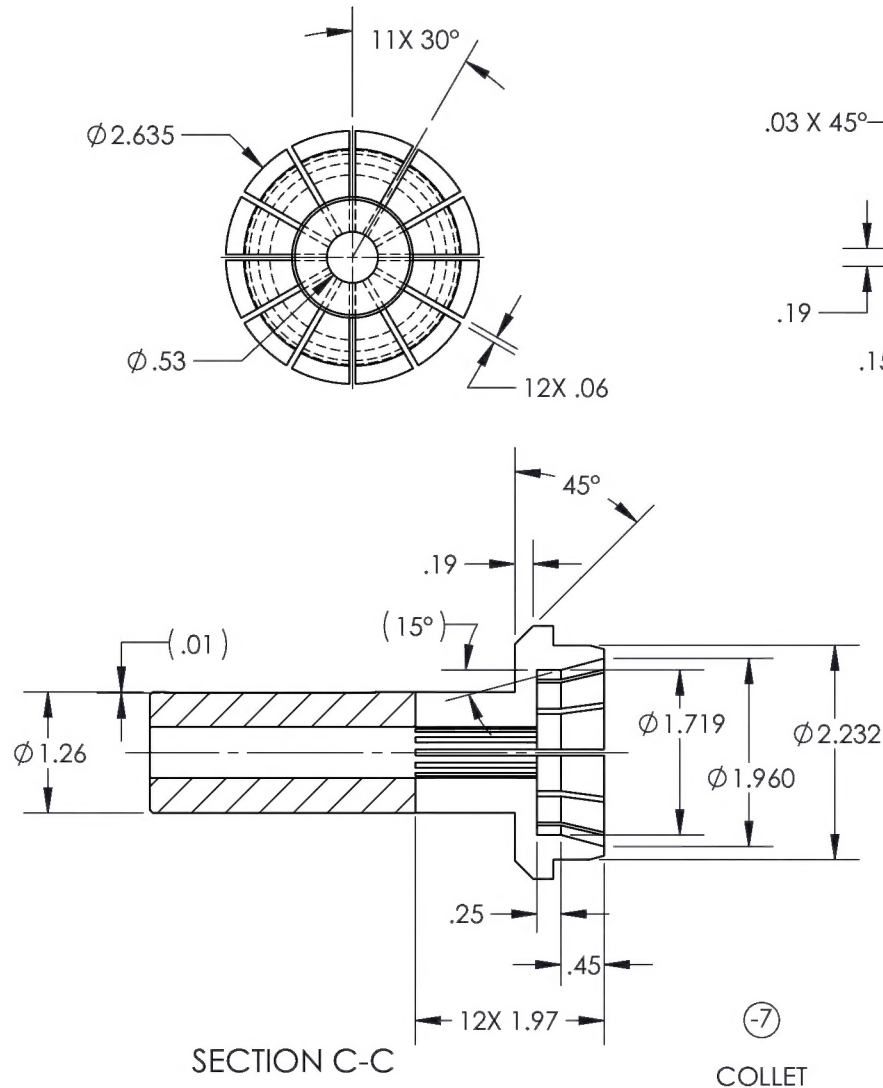
NOTE:
1. USE FOR BEARING 369A7951-5.

(-5)
CONE

DART AEROSPACE	
TITLE PUSHER, CLUTCH IN RACE INSTALLATION	
DWG NO. RBW6305G04731-3G-5	REV 5
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125° ✓
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: MACKOVJAK	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/30/2010	USED ON MODEL
	AW139
	SHEET 4 OF 6

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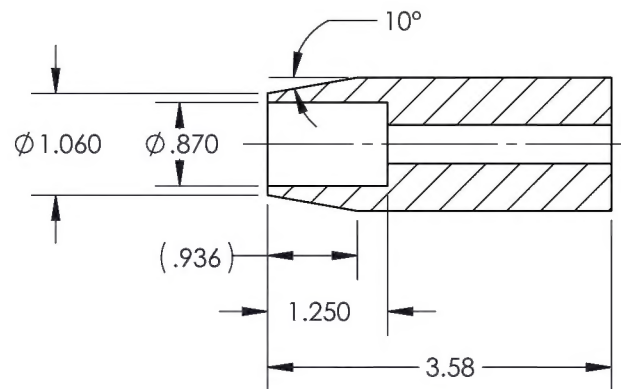
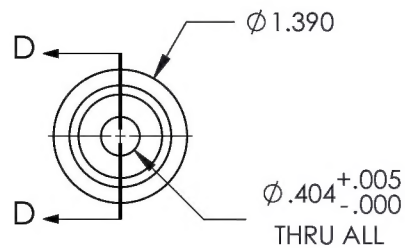
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-7 ADDED HEAT TREAT RC 35-40.	1/20/2011	RJC	RW
2		-7 ADDED MISSING DIM'S FOR FLAT TO ENGRAVE T/N.	5/31/2011	RJC	RW
3		-7 CH'D DIM'S TO MEET FACTORY PART.	12/14/2011	RJC	SE
4		-7 REMOVED INCORRECT T/N TEXT.	1/30/2013	BIM	SE
5	16-0193	-7 CH'D DIM'S WAS 30° IS 12X 30°, WAS Ø.532 IS Ø.53, WAS .030 X 45° IS .03 X 45°, WAS .150 X 15° IS .15 X 15°, WAS 1.260 IS Ø1.26, WAS .188 IS .19, WAS .150 IS .15, WAS 2.200 IS 2.20, WAS 4.728 IS 4.73, WAS .250 IS .25, WAS .450 IS .45, WAS 1.965 IS 1.97, WAS 15° IS (15°), CH'D MAT'L WAS 4140 IS 4140/4142. CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE. CH'D ENGRAVE NOTE WAS ENGRAVE T/N IS ENGRAVE P/N.	10/27/2016	RJC	SM



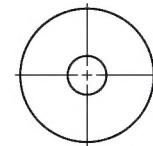
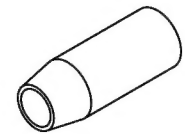
DART AEROSPACE	
TITLE PUSHER, CLUTCH IN RACE INSTALLATION	
DWG NO. RBW6305G04731-3G-7	REV 5
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 35-40	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125°
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: MACKOVJAK	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/30/2010	USED ON MODEL
	AW139
	SHEET 5 OF 6

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		-9 CH'D DIMENSIONS TO MEET FACTORY PART.	12/14/2011	RJC	
5	16-0193	-9 CH'D DIM WAS 3.580 IS 3.58, CH'D MAT'L WAS 1018 IS 1018/1020 CR, CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE. DELETED ENGRAVE NOTE.	10/27/2016	RJC	SM



SECTION D-D



(-9)
BULLET

DART AEROSPACE	
TITLE PUSHER, CLUTCH IN RACE INSTALLATION	
DWG NO. RBW6305G04731-3G-9	REV 5
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125° ✓
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: MACKOVJAK	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/30/2016	USED ON MODEL
	AW139
	SHEET 6 OF 6